

**Work Order ID 85183**

Monday, June 04, 2012 11:20:28 AM

**\*85183\***

Page 1

Item ID: PB67-43001-47

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Base Assembly

Start Date: 6/4/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 6/15/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: *MF*Date: *12-06-04*

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

B67-43001-47

Rev C

100

0.00

**\*100\***

Large Fab

Large Fab

Memo

0.00

Large Fab

1- weld as per dwg B67-43001 using jig

*1 0**K*  
*12-06-19*

110

QC5- Inspect part completeness to step on W/O

0.00

**\*110\***

QC

Memo

0.00

Quality Control

*S. 7/10/19*

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*1 0 12-06-19*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 85183**

Monday, June 04, 2012 11:20:28 AM

**\*85183\***

Page 2

Item ID: PB67-43001-47

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Base Assembly

Start Date: 6/4/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 6/15/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date: \_\_\_\_\_

Tooling:

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC:

Date: \_\_\_\_\_

SPC (Y/N):

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

| Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---------|--------|-----------|------------|------------|---------------|-------------|
|---------|--------|-----------|------------|------------|---------------|-------------|

130

Identify as per dwg & Stock Location: WMA

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

12/6/2012

mf  
12-06-19

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Monday, June 04, 2012 11:20:28 AM

Page 1

Work Order ID: 85183

Parent Item: PB67-43001-47

Parent Item Name: Base Assembly

Start Date: 6/4/2012

Required Date: 6/15/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-25 new issue DD verified by:ec  
dwg EC verified by:DD

IPP Rev C 10.09.28 per rev C

| Component Item ID/<br>Item Name               | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand  | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| D3440-11<br>Gusset (Supersedes B67-43001-241) |                        | Manufactured  | No          |                     |                  | 100             | Each               | 11.0000         | 2           | 2            |               | 12.06.19       |        |
|   |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|   |                        |               |             | ST439A              |                  | 11              |                    |                 |             |              |               |                |        |
|   |                        |               |             | 41553               |                  | 11              |                    |                 | 2           |              |               |                |        |
| PB67-43001-139<br>Square Tube                 |                        | Manufactured  | No          |                     |                  | 100             | Each               | 4.0000          | 1           | 1            |               | 12.06.19       |        |
|   |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|   |                        |               |             | ST446A              |                  | 4               |                    |                 |             |              |               |                |        |
|   |                        |               |             | 41557               |                  | 4               |                    |                 | 1           |              |               |                |        |
| PB67-43001-141<br>Square Tube                 |                        | Manufactured  | No          |                     |                  | 100             | Each               | 8.0000          | 2           | 2            |               | 12.06.19       |        |
|   |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|   |                        |               |             | ST446A              |                  | 8               |                    |                 |             |              |               |                |        |
|   |                        |               |             | 41558               |                  | 8               |                    |                 | 2           |              |               |                |        |
| PB67-43001-143<br>Square Tube                 |                        | Manufactured  | No          |                     |                  | 100             | Each               | 8.0000          | 2           | 2            |               | 12.06.19       |        |
|   |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|   |                        |               |             | ST437               |                  | 8               |                    |                 |             |              |               |                |        |
|   |                        |               |             | 41559               |                  | 8               |                    |                 | 2           |              |               |                |        |
| PB67-43001-315<br>Hook                        |                        | Manufactured  | No          |                     |                  | 100             | Each               | 6.0000          | 3           | 3            |               | 12.06.19       |        |
|   |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|   |                        |               |             | ST439               |                  | 6               |                    |                 |             |              |               |                |        |
|   |                        |               |             | 52440               |                  | 6               |                    |                 | 3           |              |               |                |        |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

8

7

6

5

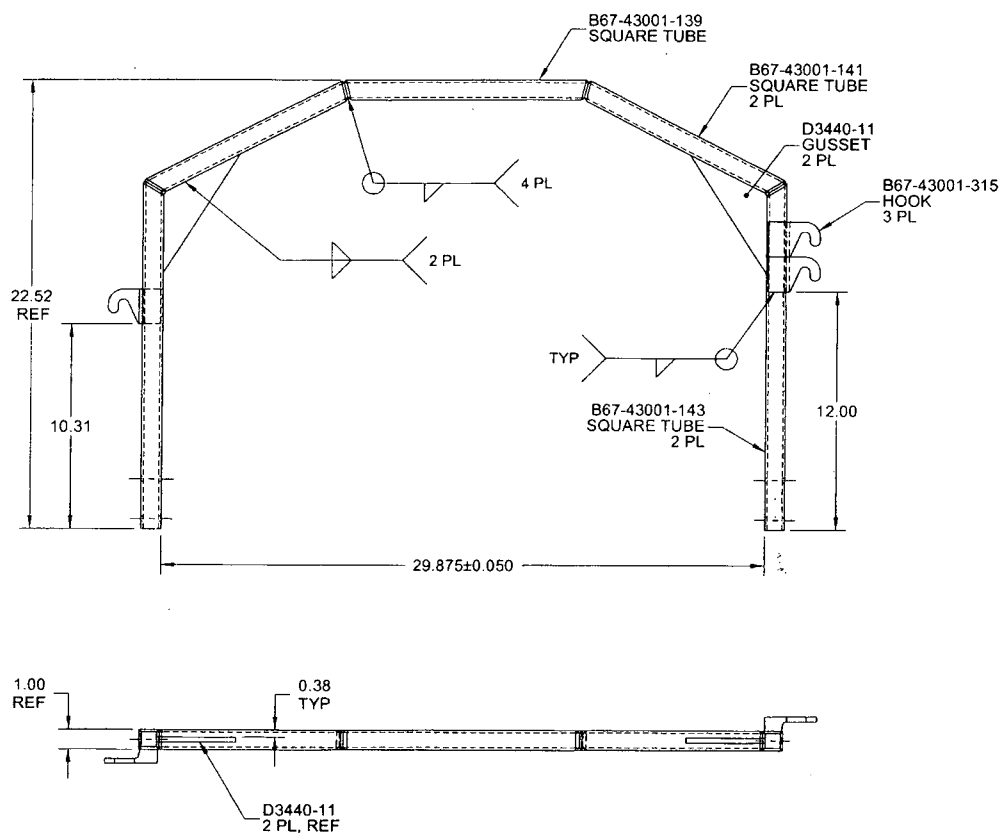
4

3

2

1

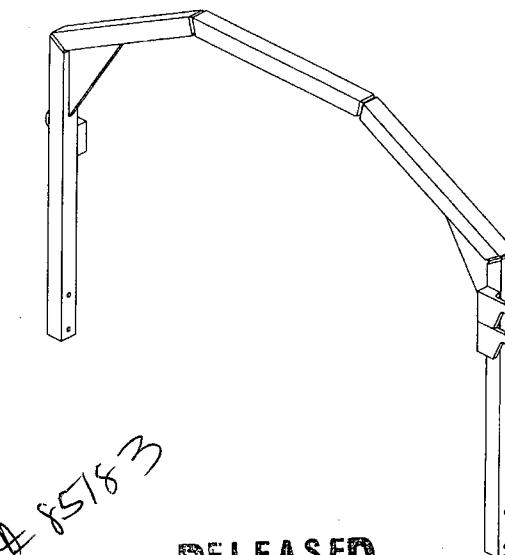
| ITEM | QTY<br>-47 | P/N           | DESCRIPTION   |
|------|------------|---------------|---------------|
| 1    | X          | B67-43001-47  | BASE ASSEMBLY |
| 3    | 1          | B67-43001-139 | SQUARE TUBE   |
| 4    | 2          | B67-43001-141 | SQUARE TUBE   |
| 5    | 2          | B67-43001-143 | SQUARE TUBE   |
| 6    | 3          | B67-43001-315 | HOOK          |
| 7    | 2          | D3440-11      | GUSSET        |



**B67-43001-47 BASE ASSEMBLY**

**NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.68 lbs
- 8) WELDING: PER QSI 004



|            |   |   |              |    |          |
|------------|---|---|--------------|----|----------|
| C          | REDRAWN PREMIER AVIATION DRAWING (AW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 15 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011. |   |              | MB | 09.06.10 |
| REV.       | DESCRIPTION   |   |              | BY | DATE     |
| DESIGN     | R/W   | DART AEROSPACE LTD  |              |    |          |
| DRAWN      |   | HAWKESBURY, ONTARIO, CANADA   |              |    |          |
| CHECKED    |    | DRAWING NO.   | REV. C       |    |          |
| MFG. APPR. |   | B67-43001-47  | SHEET 1 OF 1 |    |          |
| APPROVED   |    | TITLE   | SCALE        |    |          |
| DE APPR.   | N/A   | BASE ASSEMBLY   | NTS          |    |          |
| DATE       | 09.06.10  | COPYRIGHT © 1985 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD |              |    |          |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries